

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION                 | DESCRIPTION              | FEED TYPE         | CONVERT TO        | PART NUMBERS REQUIRED |           |             |           |             |                        |
|---|-------------|--------------------------|--------------------------|-------------------|-------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
|   | 2151827-1   | A                        | FINE CRIMP HEIGHT ADJUST | MECHANICAL        | PNEUMATIC FEED    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-1 | 2119799-1   | 2063440-1              |
|   | 2151827-2   | A                        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | SERVO LATCH PLATE | 2119951-1             | -         | 8-2151827-5 | 1901094-3 | 2-1752354-6 | 2168400-6 (QUANTITY 2) |
|   |             |                          |                          |                   | SMART APPLICATOR  | 2161326-1             | -         | 8-2151827-4 | -         | -           |                        |
|   |             |                          |                          |                   | MECHANICAL FEED   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-1 | -           |                        |
|   | 2151827-5   | A                        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | SERVO LATCH PLATE | 2119951-1             | -         | 8-2151827-5 | 1901094-3 | 2-1752354-6 | 2168400-6 (QUANTITY 2) |
|   |             |                          |                          |                   | SMART APPLICATOR  | 2161326-1             | -         | 8-2151827-4 | -         | -           |                        |
|   | 2151827-6   | A                        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE | -                 | -                     | -         | -           | -         | -           | -                      |
| 2151827-7                                     | A           | FINE CRIMP HEIGHT ADJUST | NONE                     | -                 | -                 | -                     | -         | -           | -         | -           |                        |
| 7-2151827-7                                   | A           | CRIMP TOOLING KIT        | -                        | -                 | -                 | -                     | -         | -           | -         | -           |                        |

| APPLICATOR DATA                   |                |      |
|-----------------------------------|----------------|------|
| CRIMP WIRE                        | SIZE           | TYPE |
| WIRE                              | 2.29 mm [.090] | F    |
| INSUL                             | 3.94 mm [.155] | F    |
| APPLICATOR INSTRUCTIONS 408-10389 |                |      |

| TERMINAL DATA: LEAR TERMINAL                     | TE CRIMP SPECIFICATION                                    |
|--|---|
| TERMINAL NAME: 2.8MM BLADE                       |   |
| WIRE STRIP LENGTH<br>4.25-4.85 mm [.167-.191 IN] | INSULATION DIAMETER RANGE<br>Ø1.70-3.00 mm [.067-.118 IN] |
| TERMINAL APPLICATION SPECIFICATION               |   |
| TERMINALS APPLIED                                |   |
| TE TERMINAL<br>2113309-1                         | LEAR TERMINAL<br>771716-HK200                             |

| WIRE SIZE              | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|------------------------|----------------------------|--------------------------------|
| 2400-2900 CMA or 16AWG | 1.60+/-0.05 [.063+/-0.002] | 9.0                            |
| 1600-1900 CMA or 18AWG | 1.45+/-0.05 [.057+/-0.002] | 10.6                           |
| 1100-1186 CMA or 20AWG | 1.34+/-0.05 [.053+/-0.002] | 11.5                           |

- 1 RECOMMENDED SPARE PARTS
- 2 GREASE BEARING SURFACES LIGHTLY
- 3 LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151827-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151827-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151827-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151827-6
- 5 ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62, 180 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 180 & 242.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 9 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 10 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 11 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12 WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.20.

**\*WARNING**  
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

| -77 | -7 | -6 | -5 | -2 | -1 | PART NO   | DESCRIPTION                     | ITEM NO |
|-----|----|----|----|----|----|-----------|---------------------------------|---------|
| -   | -  | 1  | -  | -  | -  | 2119957-2 | APPLICATOR SHIM PACK            | 260     |
| -   | 1  | -  | 1  | 1  | 1  | 8-21084-0 | O-RING, .676 ID, .070 DIA. MAT. | 252     |
| -   | -  | -  | -  | 1  | -  | 2119640-1 | PUSH ROD, AIR FEED              | 250     |
| -   | -  | -  | -  | 1  | -  | 2079988-1 | BUSHING, LCH5-12, MISUMI        | 249     |
| -   | -  | -  | -  | 1  | -  | 2119641-1 | FEED CAM, AIR FEED              | 248     |
| -   | 1  | -  | 1  | 1  | 1  | 2119798-1 | DETENT PIN                      | 247     |
| -   | 1  | -  | 1  | 1  | 1  | 1-22279-3 | SPRING, COMPRESSION             | 246     |

**ATLANTIC VERSION**  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

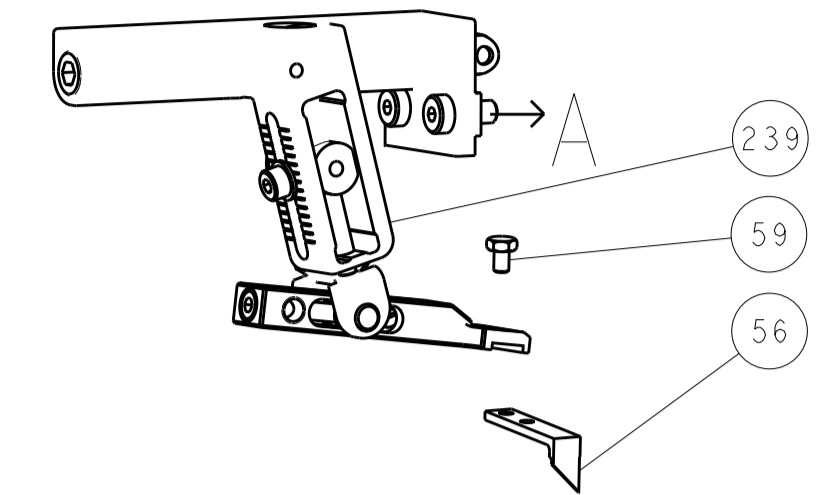
| SET UP GAUGE | LOC | DIST | REVISIONS |          |             |           |     |      |
|--------------|-----|------|-----------|----------|-------------|-----------|-----|------|
| 2119599-1    | A   | 66   | P         | LTN      | DESCRIPTION | DATE      | OWN | APVD |
|              |     |      | A         | RELEASED |             | 09JAN2013 | CC  | SX   |

|   |     |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | -   | 1   | -   | -   | -   | 2119758-1   | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245 |
| - | 1   | 1   | 1   | 1   | 1   | 2119082-9   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244 |
| - | 1   | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1   | 1   | 1   | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242 |
| - | 1   | 1   | 1   | 1   | 1   | 7-18023-7   | SCR, SKT HD CAP M3 X 4.0            | 241 |
| - | -   | 2   | 2   | -   | -   | 2168400-6   | SHCS, LOW HEAD, RoHS, M5 X 16       | 240 |
| - | -   | -   | -   | -   | 1   | 2119580-1   | MECHANICAL FEED ASSEMBLY            | 239 |
| - | -   | -   | -   | 1   | -   | 2063440-1   | AIR FEED MODULE                     | 238 |
| - | -   | 1   | 1   | -   | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213 |
| - | -   | 1   | 1   | -   | -   | 1901094-3   | SPACER, FEEDER                      | 198 |
| - | 1   | 1   | 1   | 1   | 1   | 2-1752354-5 | STANDOFF, HOLD-DOWN                 | 180 |
| - | 1   | 1   | 1   | 1   | 1   | 9931111-1   | PIN, SLOTTED SPRING 3.0 X 20.0      | 177 |
| - | 1   | 1   | 1   | 1   | 1   | 8-22280-7   | SPRING, COMPRESSION                 | 176 |
| - | 1   | 1   | 1   | 1   | 1   | 1752353-2   | GUIDE PIN, HOLDDOWN                 | 175 |
| - | 1   | 1   | 1   | 1   | 1   | 1901680-2   | GUIDE PIN, HOLDDOWN                 | 174 |
| - | -   | -   | -   | 2   | -   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 |
| - | 1   | 1   | 1   | 1   | 1   | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY      | 166 |
| - | REF | REF | REF | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164 |
| - | -   | -   | -   | 1   | -   | 240638-1    | SPRING, FEED FINGER                 | 163 |
| - | -   | -   | -   | 1   | -   | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854      | 137 |
| - | -   | -   | -   | 1   | -   | 2119799-1   | HOLDER, FEED FINGER, AF             | 136 |
| - | -   | REF | REF | -   | -   | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED             | 135 |
| - | -   | 1   | 1   | -   | -   | 1633743-1   | SERVO FEED LATCH ASM                | 133 |
| - | 1   | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 119 |
| - | -   | REF | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117 |
| - | 1   | 1   | 1   | 1   | 1   | 455888-4    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71  |
| - | 1   | 1   | 1   | 1   | 1   | 2119791-9   | DEPRESSOR, WIRE                     | 70  |
| - | 1   | 1   | 1   | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69  |
| - | 1   | -   | -   | 1   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67  |
| - | 2   | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS              | 66  |
| - | 1   | -   | 1   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63  |
| - | 3   | -   | 3   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62  |
| - | 1   | 1   | 1   | 1   | 1   | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)            | 60  |
| - | -   | -   | -   | 1   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |
| - | -   | -   | -   | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 4   | 4   | 4   | 4   | 4   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 54  |
| - | 1   | 1   | 1   | 1   | 1   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           | 52  |
| - | 1   | 1   | 1   | 1   | 1   | 1901681-1   | HOLDDOWN, TERMINAL                  | 51  |
| - | -   | -   | -   | 1   | 2   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49  |
| - | -   | -   | -   | -   | 1   | 2119652-1   | FEED CAM, PRE FEED                  | 48  |
| - | -   | -   | -   | -   | 1   | 2119653-1   | FEED CAM, POST FEED                 | 47  |
| - | 1   | 1   | 1   | 1   | 1   | 2119656-9   | APPLICATOR BASIC ASSEMBLY, SF       | 46  |
| - | 1   | -   | 1   | 1   | 1   | 2119370-1   | RAM, AMP STYLE, SIDE FEED           | 44  |
| - | 1   | 1   | 1   | 1   | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41  |
| - | 1   | -   | 1   | 1   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40  |
| - | 1   | -   | 1   | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39  |
| - | 1   | 1   | 1   | 1   | 1   | 2119644-2   | RAM WASHER, PRECISION               | 38  |
| - | 1   | 1   | 1   | 1   | 1   | 2119085-1   | FA HEAD, ATLANTIC STYLE             | 37  |
| - | 1   | -   | 1   | 1   | 1   | 2119092-1   | BOLT, ADJUSTMENT                    | 35  |
| - | 1   | 1   | 1   | 1   | 1   | 1752356-6   | SUPPORT, TERMINAL                   | 34  |
| - | 2   | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33  |
| - | 1   | 1   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 x 8mm LONG    | 32  |
| - | 1   | 1   | 1   | 1   | 1   | 1-1320908-2 | SPACER, STRIP GUIDE                 | 30  |
| - | 1   | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29  |
| - | 1   | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28  |
| - | 1   | 1   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24  |
| - | 1   | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21  |
| - | 1   | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 20  |
| - | 1   | 1   | 1   | 1   | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19  |
| - | 1   | 1   | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13  |
| - | 1   | 1   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12  |
| - | 1   | 1   | 1   | 1   | 1   | 1-356885-4  | STOP, SHEAR                         | 11  |
| - | 1   | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10  |
| - | 1   | 1   | 1   | 1   | 1   | 318707-1    | FLOATING SHEAR, FRONT               | 9   |
| - | 1   | 1   | 1   | 1   | 1   | 1633921-1   | ANVIL, COMBINATION                  | 8   |
| - | -   | -   | -   | -   | -   | -           | -                                   | 7   |
| - | -   | -   | -   | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 1   | 1   | 1   | 2119757-9   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 1   | 238011-2    | BLOCK, CRIMPER SPACER               | 4   |
| - | 1   | 1   | 1   | 1   | 1   | 3-2119582-6 | CRIMPER, INSULATION F PREMIUM       | 3   |
| - | -   | -   | -   | -   | -   | -           | -                                   | 2   |
| - | 1   | 1   | 1   | 1   | 1   | 1-456406-5  | CRIMPER, WIRE PREMIUM               | 1   |

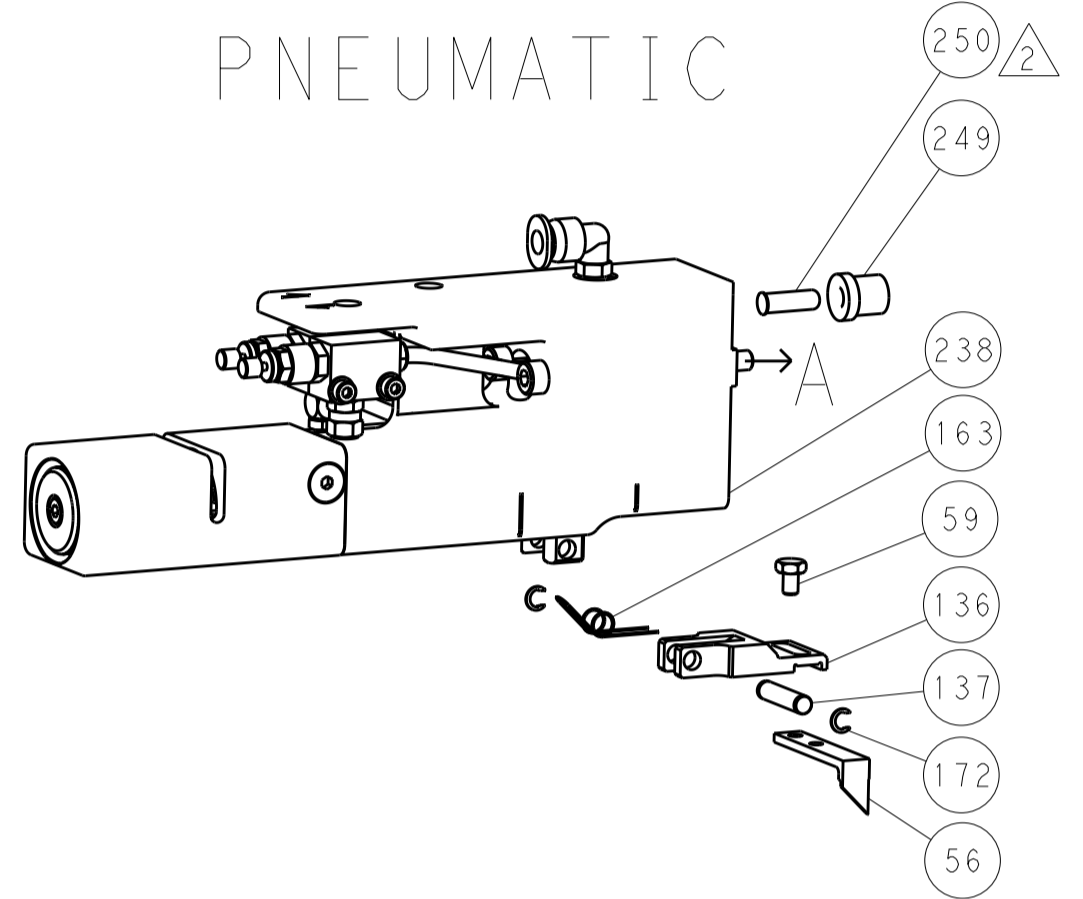
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|--|---------|--|-------------|--------------|---------------|--------------|--------------|-------|-------|
| mm                                     | 0 PLC ± | 1 PLC ±0.1                             | 2 PLC ±0.02 | 3 PLC ±0.005 | 4 PLC ±0.0005 | ANGLES ±     | FINISH       | APVD  | DATE  |
| MATERIAL                               |         | FINISH                                 |             | WEIGHT       | SCALE         |              | SHEET 1 OF 4 |       | REV A |
| Customer Accessible Production Drawing |         |  |             | SCALE 1:1    |               | SHEET 1 OF 4 |              | REV A |       |

| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LYN | DESCRIPTION | DATE | DWN | APVD |
|     |    | -    |     | SEE SHEET 1 |      |     |      |

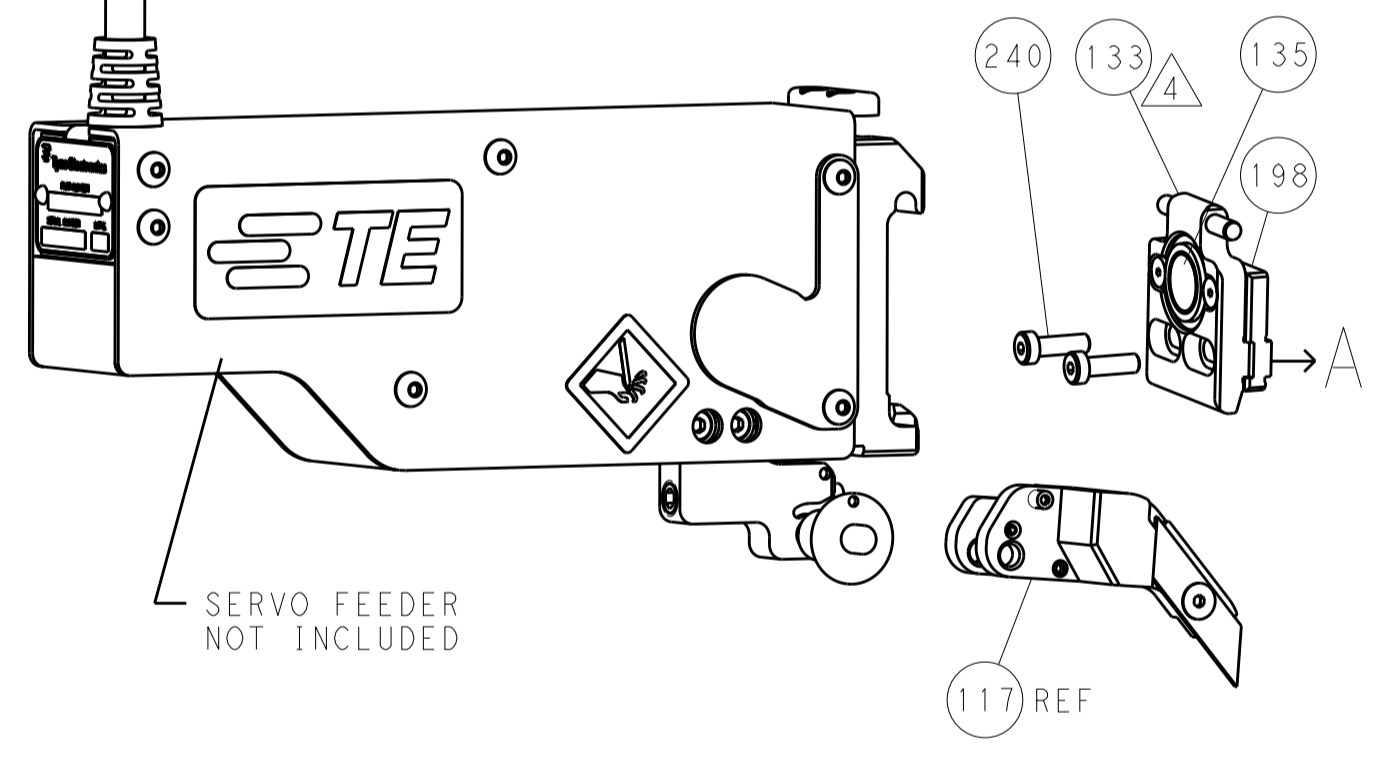
### FEED TYPE MECHANICAL



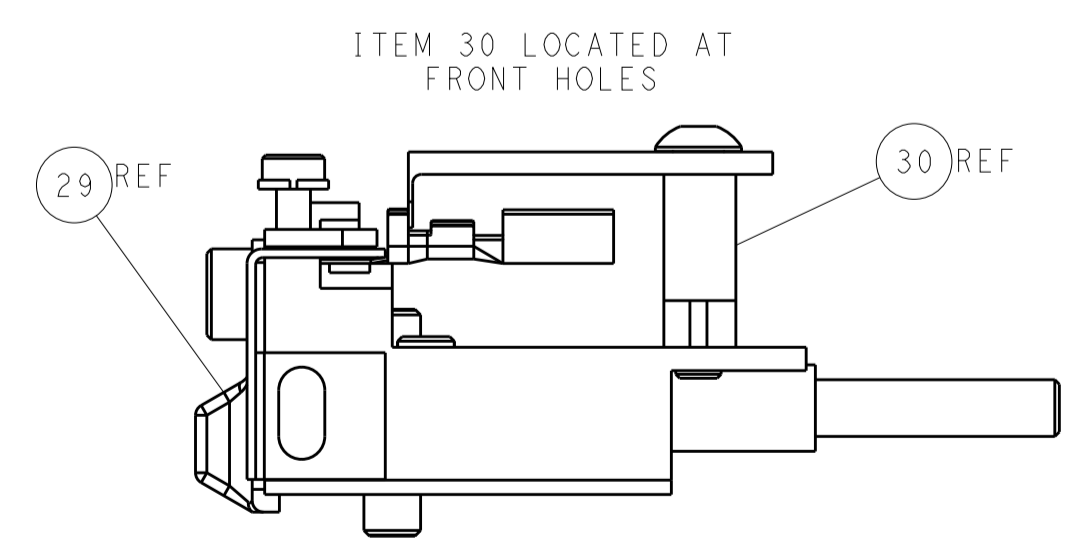
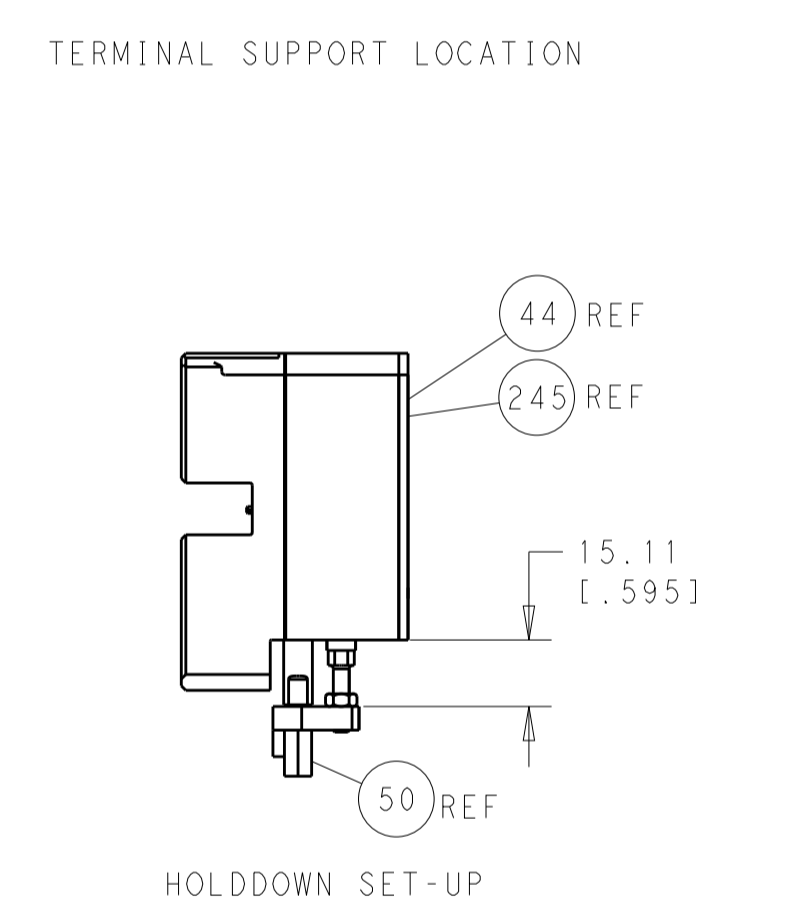
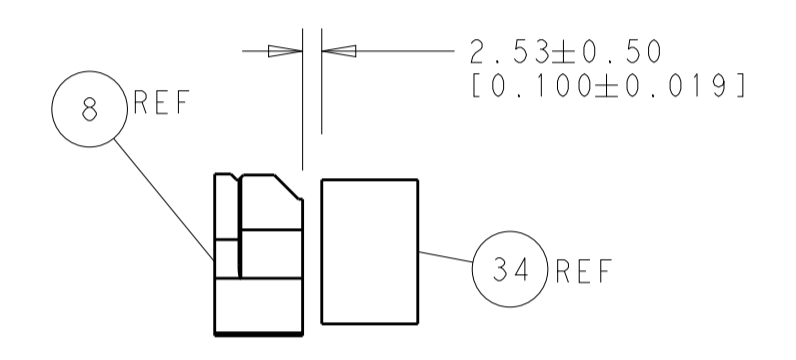
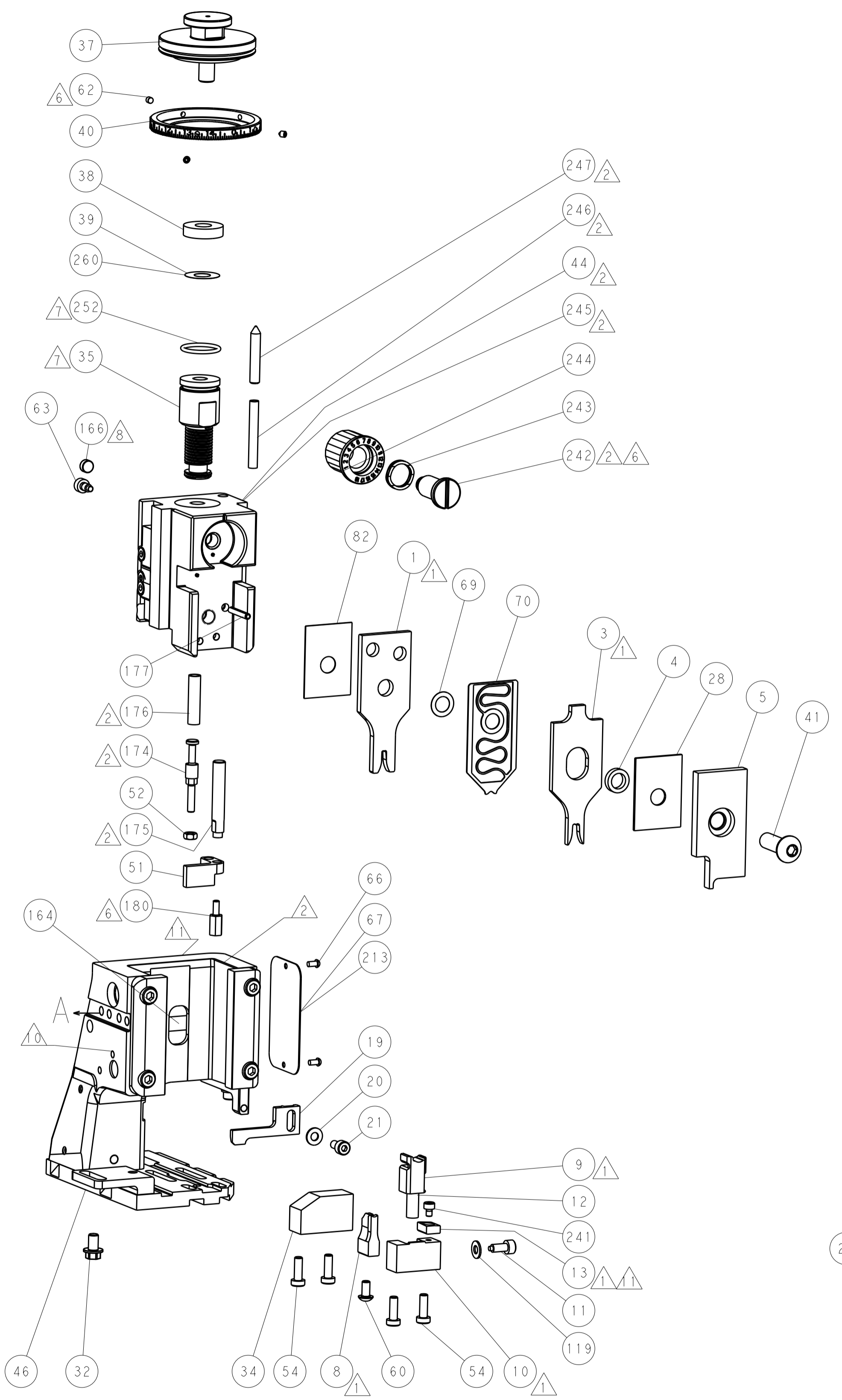
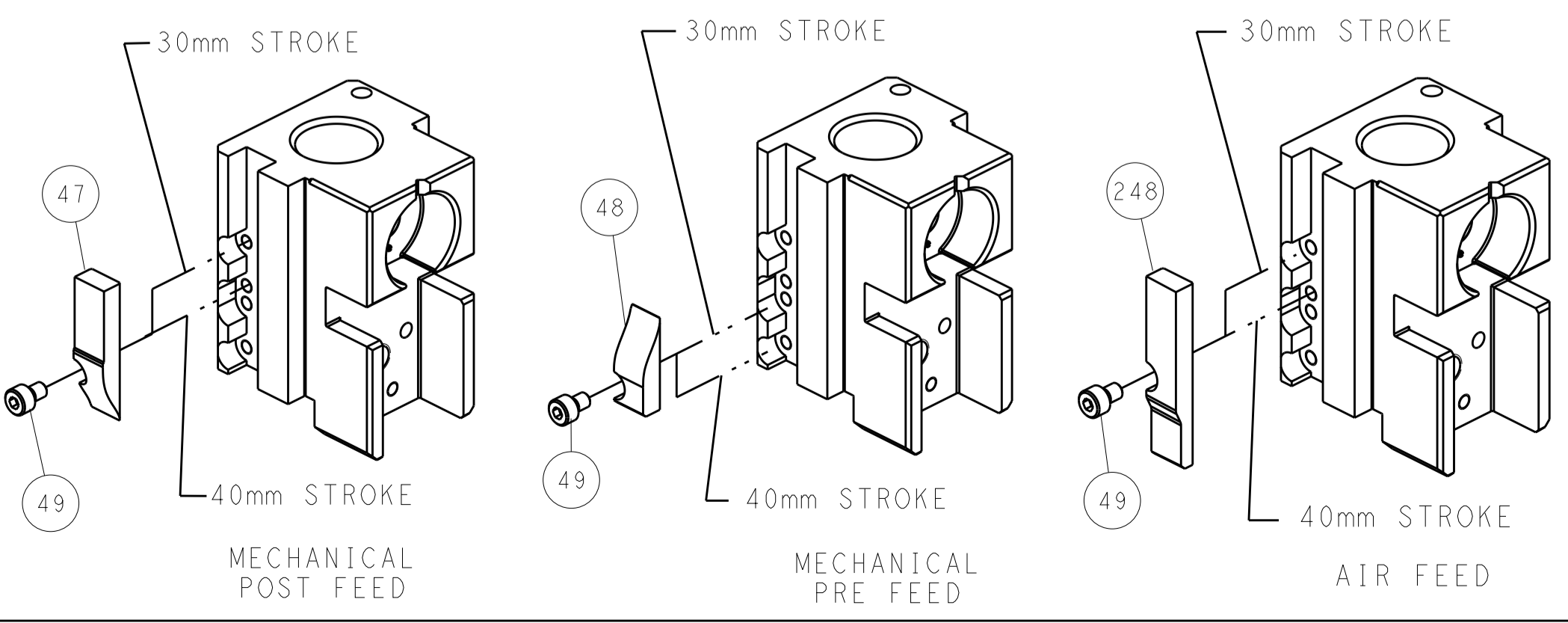
### PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITIONS



**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

|  |            |  |             |                                 |               |                      |                           |
|--|------------|--|-------------|---------------------------------|---------------|----------------------|---------------------------|
| DIMENSIONS:                            |            | TOLERANCES UNLESS OTHERWISE SPECIFIED: |             | DWN C. CHEN 28NOV2012           |               | TE Connectivity      |                           |
| mm                                     | 0 PLC ±0.1 | 1 PLC ±0.1                             | 2 PLC ±0.02 | 3 PLC ±0.005                    | 4 PLC ±0.0005 | APVD S. XI 28NOV2012 | Harrisburg, PA 17105-3608 |
| MATERIAL:                              |            | FINISH:                                |             | NAME Ocean Side Feed Applicator |               | RESTRICTED TO        |                           |
| Customer Accessible Production Drawing |            | SCALE 1:1                              |             | SHEET 2 of 4                    |               | REV A                |                           |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |             |                        |
|--|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
|  |             |          |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |             |                        |
|  | 2-2151827-1 | A        | FINE CRIMP HEIGHT ADJUST | MECHANICAL                     | PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-2 | 2119799-1   | 2063440-1              |
|  |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2151827-5 | 1901094-3 | 2-1752354-6 | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151827-4 | -         | -           | -                      |
|  | 2-2151827-2 | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -           | -                      |
|  |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2151827-5 | 1901094-3 | 2-1752354-6 | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151827-4 | -         | -           | -                      |
|  | 2-2151827-5 | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -           | -                      |
|  |             |          |                          |                                | PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-2 | 2119799-1   | 2063440-1              |
|  | 2-2151827-7 | A        | FINE CRIMP HEIGHT ADJUST | NONE                           | -                                 | -                     | -         | -           | -         | -           | -                      |
|  | 7-2151827-7 | A        | CRIMP TOOLING KIT        | -                              | -                                 | -                     | -         | -           | -         | -           | -                      |

| APPLICATOR DATA                   |                |      |
|-----------------------------------|----------------|------|
| CRIMP WIRE                        | SIZE           | TYPE |
| INSUL                             | 2.29 mm [.090] | F    |
|                                   | 3.94 mm [.155] | F    |
| APPLICATOR INSTRUCTIONS 408-10389 |                |      |

| TERMINAL DATA: LEAR TERMINAL       |               | TE CRIMP SPECIFICATION       |               |
|------------------------------------|---------------|------------------------------|---------------|
| TERMINAL NAME: 2.8MM BLADE         |               |                              |               |
| WIRE STRIP LENGTH                  |               | INSULATION DIAMETER RANGE    |               |
| 4.25-4.85 mm [1.67-.191 IN]        |               | Ø1.70-3.00 mm [.067-.118 IN] |               |
| TERMINAL APPLICATION SPECIFICATION |               |                              |               |
| TERMINALS APPLIED                  |               |                              |               |
| TE TERMINAL                        | LEAR TERMINAL | TE TERMINAL                  | LEAR TERMINAL |
| 2113309-1                          | 771716-HK200  |                              |               |

| WIRE SIZE              | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|------------------------|----------------------------|--------------------------------|
| 2400-2900 CMA or 16AWG | 1.60+/-0.05 [.063+/-0.002] | 9.0                            |
| 1600-1900 CMA or 18AWG | 1.45+/-0.05 [.057+/-0.002] | 10.6                           |
| 1100-1186 CMA or 20AWG | 1.34+/-0.05 [.053+/-0.002] | 11.5                           |

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151827-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151827-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151827-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62, 180 & 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

**\*WARNING**  
 ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

|     |     |     |     |     |           |                                     |         |
|-----|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| -   | 1   | 1   | 1   | 1   | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251     |
| -   | -   | -   | -   | -   | 2119640-1 | PUSH ROD, AIR FEED                  | 250     |
| -   | -   | -   | -   | -   | 2079988-1 | BUSHING, LCH5-12, MISUMI            | 249     |
| -   | 1   | 1   | 1   | 1   | 1-22279-3 | SPRING, COMPRESSION                 | 246     |
| -   | 1   | 1   | 1   | 1   | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| -77 | -27 | -25 | -22 | -21 | PART NO   | DESCRIPTION                         | ITEM NO |

**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

| SET UP GAUGE | LOC | DIST | REVISIONS |             |    |      |
|--------------|-----|------|-----------|-------------|----|------|
| 2119599-1    | A   | 66   | REV       | DATE        | BY | APPV |
|              |     |      | -         | SEE SHEET 1 | -  | -    |

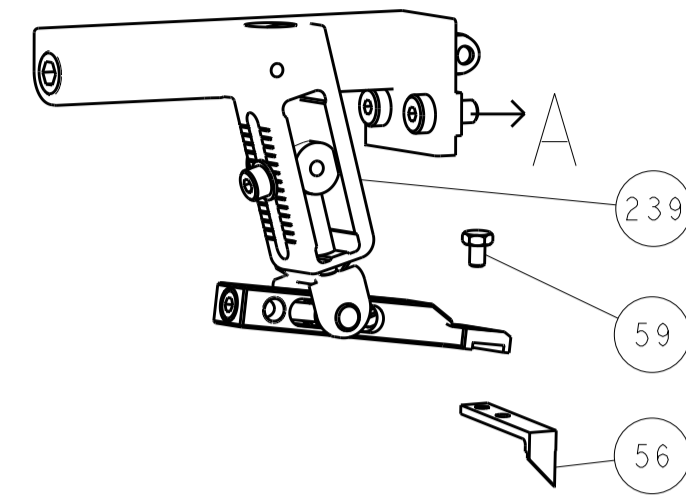
|     |     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| -   | 1   | 1   | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242     |
| -   | 1   | 1   | 1   | 1   | 7-18023-7   | SCR, SKT HD CAP M3 X 4.0            | 241     |
| -   | -   | 2   | -   | -   | 2168400-6   | SHCS, LOW HEAD, RoHS, M5 X 16       | 240     |
| -   | -   | -   | -   | 1   | 2119580-1   | MECHANICAL FEED ASSEMBLY            | 239     |
| -   | -   | -   | -   | 1   | 2063440-1   | AIR FEED MODULE                     | 238     |
| -   | -   | -   | -   | 1   | 2119740-2   | TAG, IDENTIFICATION                 | 213     |
| -   | -   | -   | -   | 1   | 1901094-3   | SPACER, FEEDER                      | 198     |
| -   | 1   | 1   | 1   | 1   | 2-1752354-5 | STANDOFF, HOLD-DOWN                 | 180     |
| -   | 1   | 1   | 1   | 1   | 993111-1    | PIN, SLOTTED SPRING 3.0 X 20.0      | 177     |
| -   | 1   | 1   | 1   | 1   | 8-22280-7   | SPRING, COMPRESSION                 | 176     |
| -   | 1   | 1   | 1   | 1   | 1752353-2   | GUIDE PIN, HOLDDOWN                 | 175     |
| -   | 1   | 1   | 1   | 1   | 1901680-2   | GUIDE PIN, HOLDDOWN                 | 174     |
| -   | -   | -   | 2   | -   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172     |
| -   | 1   | 1   | 1   | 1   | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY      | 166     |
| -   | REF | REF | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164     |
| -   | -   | -   | -   | 1   | 240638-1    | SPRING, FEED FINGER                 | 163     |
| -   | 1   | 1   | 1   | 1   | 8-21084-1   | O-RING, .801 ID, .070 DIA, MAT.     | 152     |
| -   | -   | -   | -   | 1   | 2119641-2   | FEED CAM, AIR FEED                  | 151     |
| -   | 1   | 1   | 1   | 1   | 2119798-2   | DETENT PIN                          | 145     |
| -   | 1   | 1   | 1   | 1   | 2079383-8   | SCR, BHSC, RoHS (M4 X 16)           | 144     |
| -   | 4   | 4   | 4   | 4   | 2168400-5   | SHCS, LOW HEAD, RoHS, M4 X 20       | 143     |
| -   | -   | -   | -   | 1   | 2119653-2   | FEED CAM, POST FEED                 | 142     |
| -   | 1   | 1   | 1   | 1   | 1-2119656-0 | APPLICATOR BASIC ASSEMBLY, SF       | 141     |
| -   | 1   | 1   | 1   | 1   | 2119650-1   | RAM, ASIAN STYLE, SIDE FEED         | 140     |
| -   | 1   | 1   | 1   | 1   | 2119092-2   | BOLT, ADJUSTMENT                    | 139     |
| -   | -   | -   | -   | 1   | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854      | 137     |
| -   | -   | -   | -   | 1   | 2119799-1   | HOLDER, FEED FINGER, AF             | 136     |
| -   | -   | REF | -   | -   | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED             | 135     |
| -   | -   | -   | -   | 1   | 1633743-1   | SERVO FEED LATCH ASM                | 133     |
| -   | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 119     |
| -   | -   | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117     |
| -   | 1   | 1   | 1   | 1   | 455888-4    | SPACER, CRIMPER                     | 82      |
| -   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -   | 1   | 1   | 1   | 1   | 2119791-9   | DEPRESSOR, WIRE                     | 70      |
| -   | 1   | 1   | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69      |
| -   | 1   | -   | -   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67      |
| -   | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS              | 66      |
| -   | 1   | 1   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63      |
| -   | 3   | 3   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 X 4.0 | 62      |
| -   | -   | -   | -   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59      |
| -   | -   | -   | -   | 1   | 1338685-1   | PAWL, FEED                          | 56      |
| -   | 1   | 1   | 1   | 1   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           | 52      |
| -   | 1   | 1   | 1   | 1   | 1901681-1   | HOLDDOWN, TERMINAL                  | 51      |
| -   | -   | -   | -   | 1   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49      |
| -   | -   | -   | -   | 1   | 2119652-1   | FEED CAM, PRE FEED                  | 48      |
| -   | 1   | 1   | 1   | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41      |
| -   | 1   | 1   | 1   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40      |
| -   | 1   | 1   | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39      |
| -   | 1   | 1   | 1   | 1   | 2119644-2   | RAM WASHER, PRECISION               | 38      |
| -   | 1   | 1   | 1   | 1   | 1752356-6   | SUPPORT, TERMINAL                   | 34      |
| -   | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33      |
| -   | 1   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 X 8mm LONG    | 32      |
| -   | 1   | 1   | 1   | 1   | 1-1320908-2 | SPACER, STRIP GUIDE                 | 30      |
| -   | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29      |
| -   | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28      |
| -   | 1   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24      |
| -   | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21      |
| -   | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 20      |
| -   | 1   | 1   | 1   | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19      |
| -   | 1   | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13      |
| -   | 1   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12      |
| -   | 1   | 1   | 1   | 1   | 1-356885-4  | STOP, SHEAR                         | 11      |
| -   | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10      |
| -   | 1   | 1   | 1   | 1   | 318707-1    | FLOATING SHEAR, FRONT               | 9       |
| -   | 1   | 1   | 1   | 1   | 1633921-1   | ANVIL, COMBINATION                  | 8       |
| -   | -   | -   | -   | -   | -           | -                                   | 7       |
| -   | -   | -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 1   | 1   | 2119757-9   | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 1   | 1   | 238011-2    | BLOCK, CRIMPER SPACER               | 4       |
| -   | 1   | 1   | 1   | 1   | 3-2119582-6 | CRIMPER, INSULATION F PREMIUM       | 3       |
| -   | -   | -   | -   | -   | -           | -                                   | 2       |
| -   | 1   | 1   | 1   | 1   | 1-456406-5  | CRIMPER, WIRE PREMIUM               | 1       |
| -77 | -27 | -25 | -22 | -21 | PART NO     | DESCRIPTION                         | ITEM NO |

|                       |  |  |  |
|-----------------------|--|--|--|
| DIMENSIONS:<br>mm<br> | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±.1<br>1 PLC ±0.1<br>2 PLC ±0.2<br>3 PLC ±0.05<br>4 PLC ±0.005<br>ANGLES ±.1 | DWN C. CHEN 28NOV2012<br>CHK S. XI 28NOV2012<br>APVD J. CRUZ 28NOV2012 | NAME<br><b>STE</b> TE Connectivity<br>Harrisburg, PA 17105-3608<br>Ocean Side Feed<br>Applicator |
| MATERIAL              | FINISH   | WEIGHT   | SCALE 1:1 SHEET 3 OF 4 REV A   |

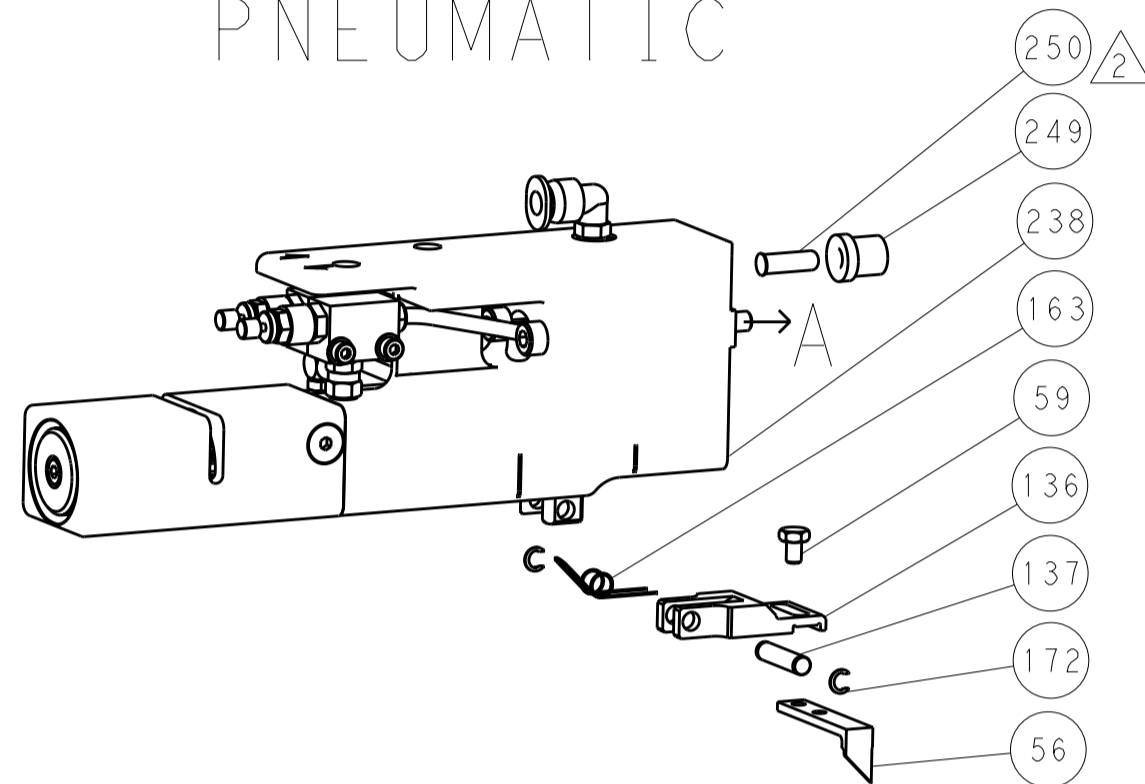
| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTM | DESCRIPTION | DATE | OWN | APVD |
|     |    | -    |     | SEE SHEET 1 |      |     |      |

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

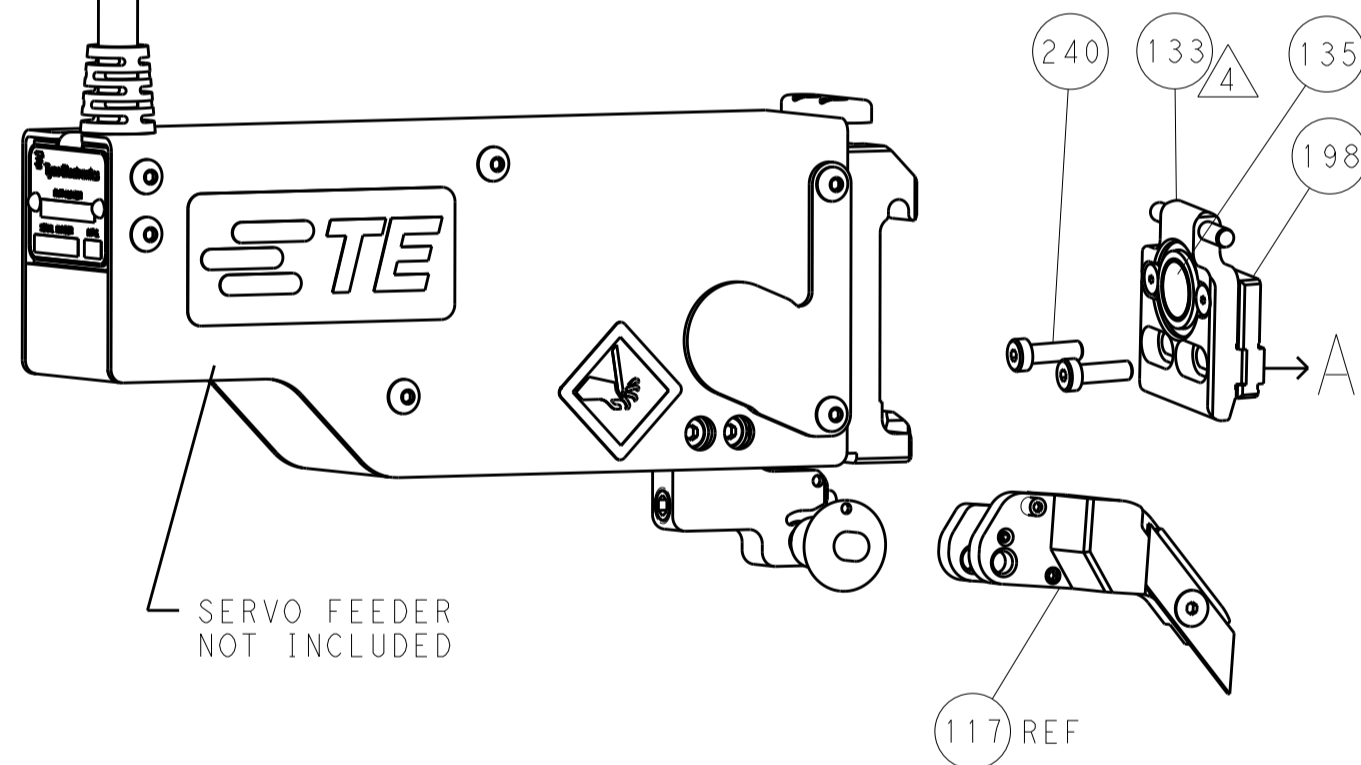
# FEED TYPE MECHANICAL



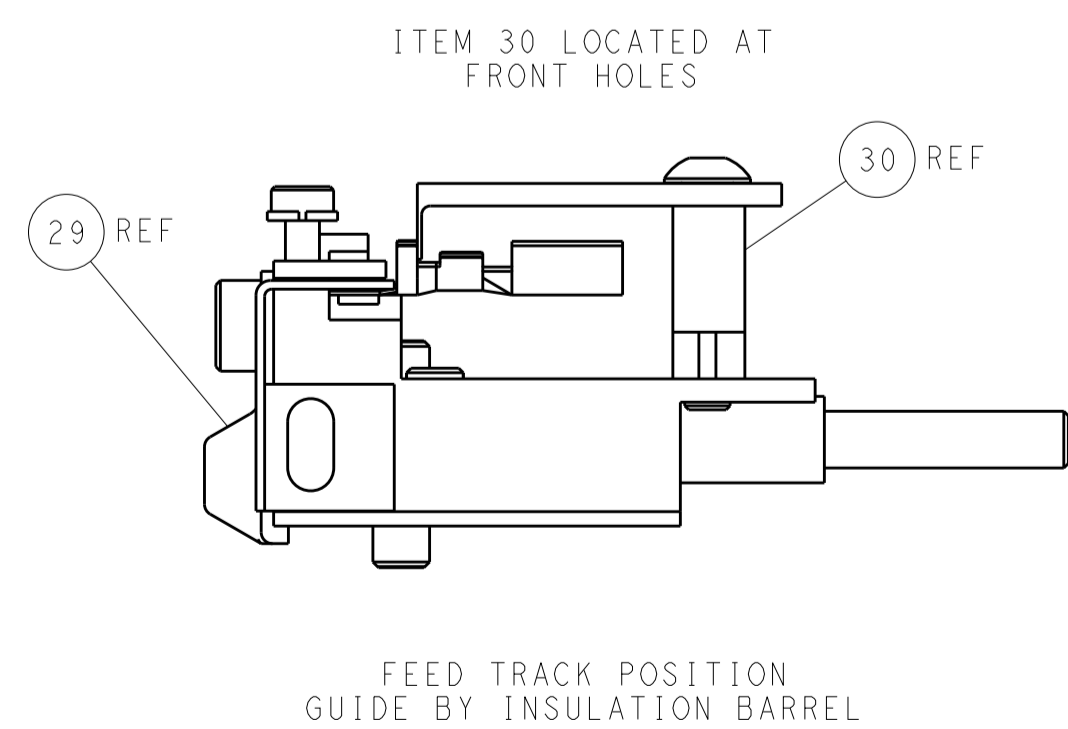
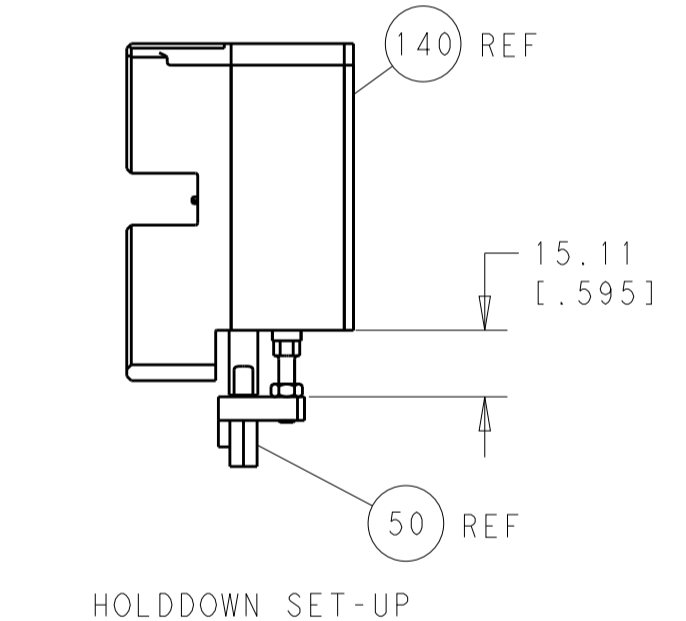
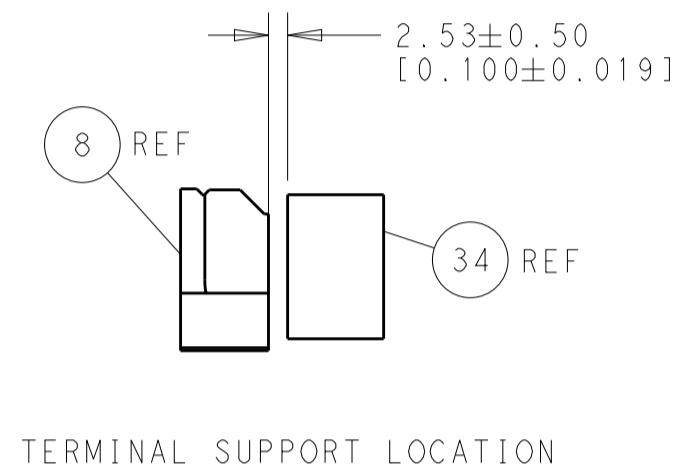
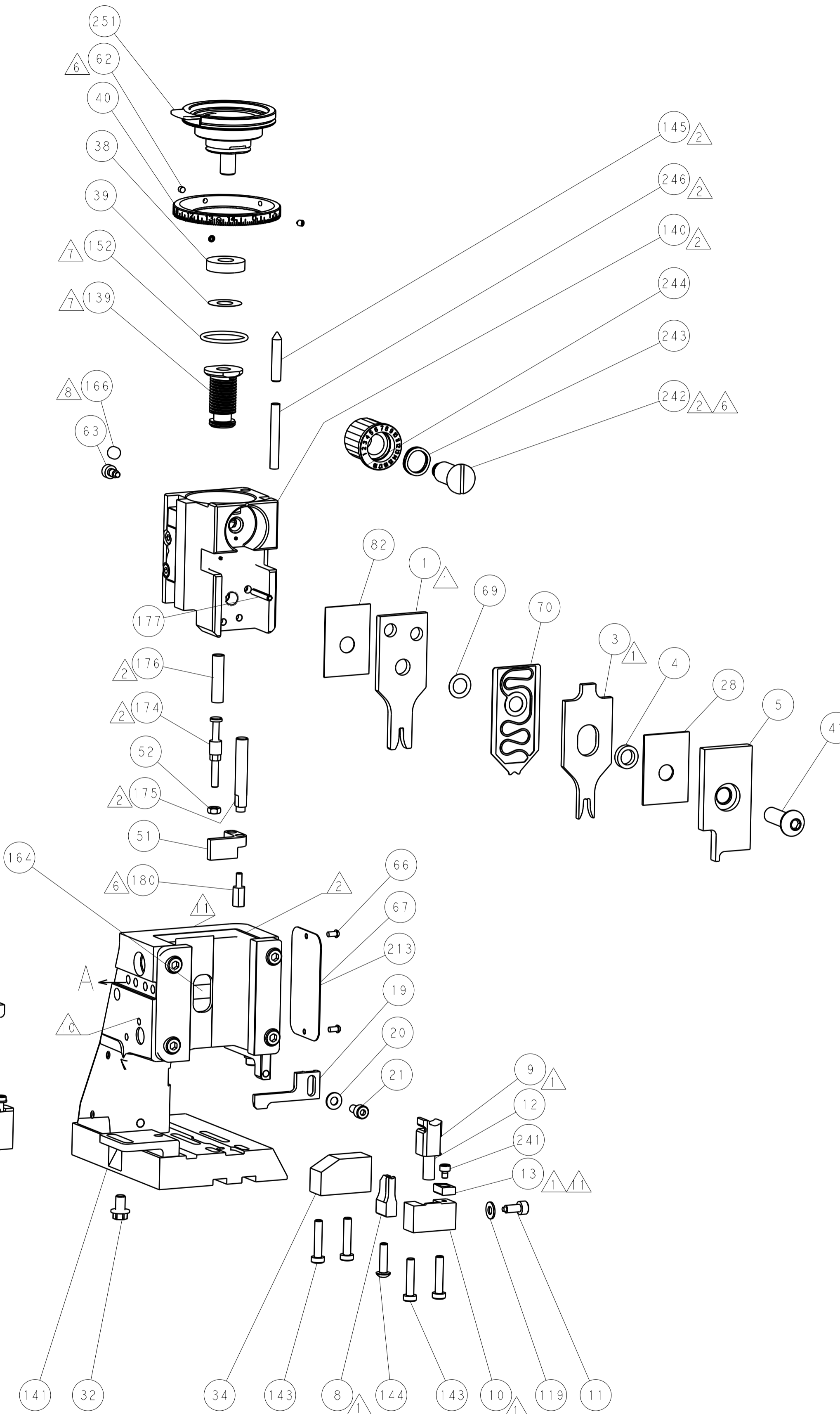
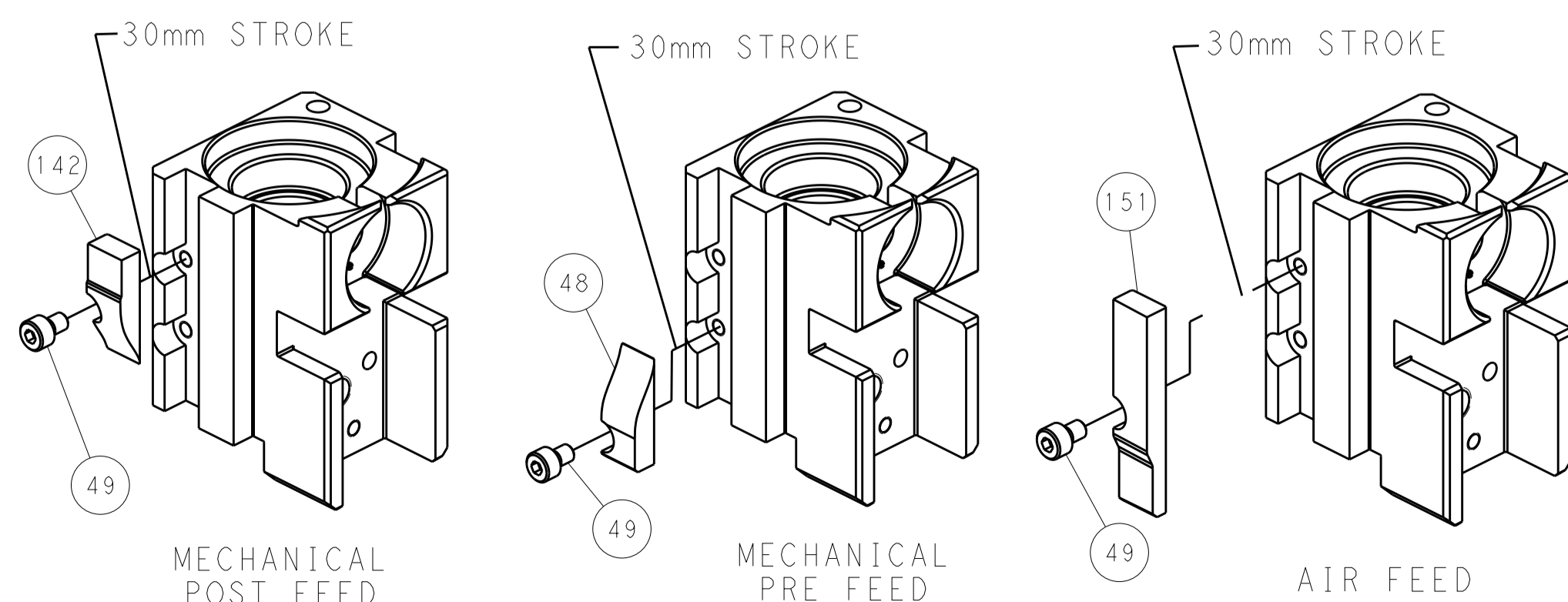
# PNEUMATIC



# SERVO LATCH PLATE



# CAM POSITIONS



**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

|             |            |  |             |   |               |                              |                           |
|-------------|------------|--|-------------|---|---------------|------------------------------|---------------------------|
| DIMENSIONS: |            | TOLERANCES UNLESS OTHERWISE SPECIFIED: |             | DWN C. CHEN 28NOV2012                         |               | TE Connectivity              |                           |
| mm          | 0 PLC ±0.1 | 1 PLC ±0.1                             | 2 PLC ±0.02 | 3 PLC ±0.005                                  | 4 PLC ±0.0005 | APVD J. CRUZ 28NOV2012       | Harrisburg, PA 17105-3608 |
| MATERIAL:   |            | FINISH:                                |             | NAME Ocean Side Feed Applicator               |               | RESTRICTED TO                |                           |
|             |            |  |             | SIZE CAGE CODE DRAWING NO. A1 00779 C=2151827 |               | SCALE 1:1 SHEET 4 OF 4 REV A |                           |